

Work Order ID 120236

June-09-14 11:33:25 AM

120236

Page 1

Item ID: D3302-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Doubler

Stop ***NS2***

Start Date: 6/04/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3302

Rev B2

105

0.00

105

Purchasing

Purchasing

Memo

ISUUE PO

CUT PER DRWG D3302 REV.B2

0.00

CoL 14/10/12 10

115

Receive & Inspect for Damage & Matl Certs

0.00

115

Packaging

Packaging

Memo

0.00

14/12/11 (10)

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Quality Control

Memo

0.00

14/11/18

10

Work Order ID 120236

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120236

Page 2

Item ID: D3302-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 6/04/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 36 9-89
130 *130* Small Fab	Small Fab	0.00				10x			14/07/18	
	Memo	0.00								
	Deburr break all unmarked sharp edges 0.005 to 0.010									
140 *140* Brake NC	NC BRAKE	0.00				10x			14/07/18	DAS 36 9-89
	Memo	0.00								
	Form as per Dwg D3302									
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00				10				
	Memo	0.00								
	Quality Control									

P10 →
NCR 14-4145



Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: September-16-14

Details			
Raised Date 2014-08-22	Status Open	Owner Forbes, Nigel	Number NCR14-4145
Target Date 2014-10-31	Standard		Severity MAJOR
Process Inspection		Audit	
Raised By Person Downing, Eric M		Raised Against (Department or Supplier)	Fault Category
Details corrosion was found during the alodine process. the corrosion was found on the flat non bent side of the part D3302-1 B115854 qty x 10 and also D3302-3 B120236 qty x 10 parts are effected. both work orders were cut at T.P.I Industries Inc on PO#24574.			
Keywords		Product D3302-1 &-3	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	2014-08-29	2014-09-05
scrap all parts		parts scraped on work orders	
2	Gregoire, Michael	2014-08-29	
contact supplier to find out how Dart's material is being stored and request			
3	Forbes, Nigel	2014-08-29	
look into the process of handling material and storage form department to department			

Verification & Review			
Target Date	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

Work Order ID 120236***120236***

Page 3

June-09-14 11:33:25 AM

Item ID: D3302-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 6/04/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/04/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

0.00

Packaging

120236

June-09-14 11:33:25 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

Customer:

Start Date: 6/04/14 **Start Qty:** 10.00 ***10***

Required Date: 6/04/14 **Req'd Qty:** 10.00 ***10***

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

190

QC

Memo

0.00

Quality Control

Picklist Print

Page 1

June-09-14 11:33:25 AM

Work Order ID: 120236

120236

Parent Item: D3302-3

D3302-3

Parent Item Name: Doubler

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.09.02New issueKJ/JLM
IPP B06.05.02Water jet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	503.0880	0.9931	11			
M6061T6S 063									**		<u>CL 14/06/27</u>		
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT021

503.088

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

84.768

M128941

284

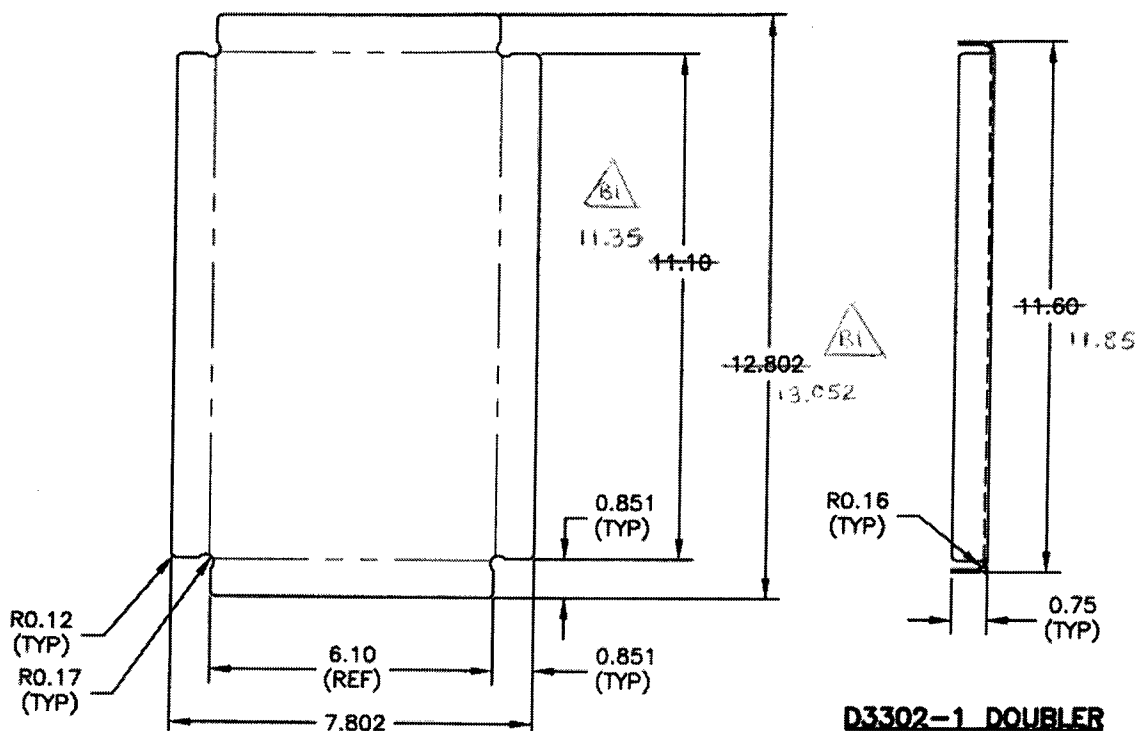
m129637

(4)



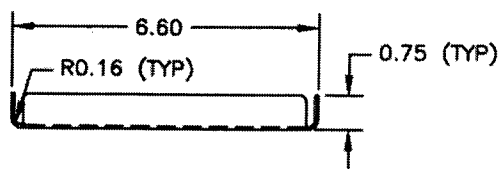
DESIGN T#	DRAWN BY T#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3	
B2	05.03.21	7.25 WAS 7.34; 8.95 WAS 9.042; 7.75 WAS 7.84 FOR D3302-3	

RELEASED
04.11.23



D3302-1 FLAT PATTERN

**D3302-1 DOUBLER
BEND DETAIL**



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120236
14-6-6

D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

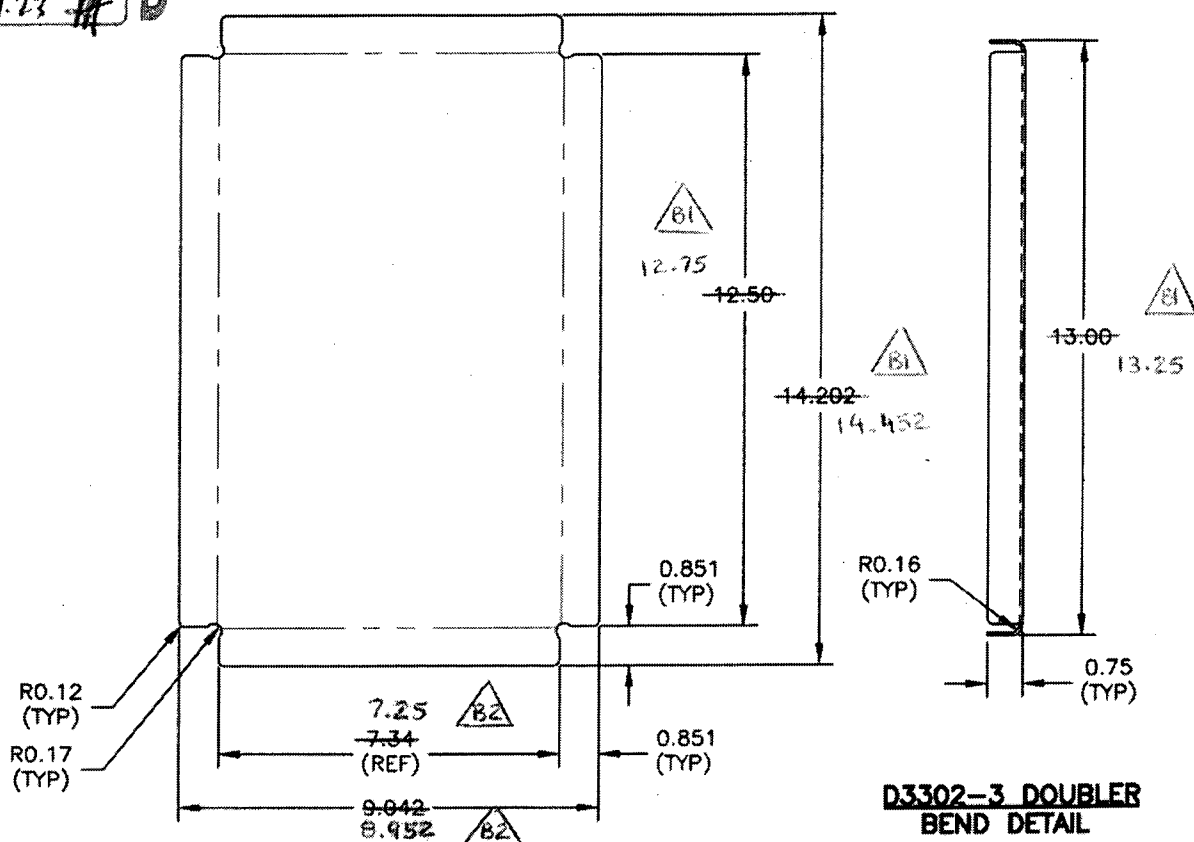
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 *#*



D3302-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

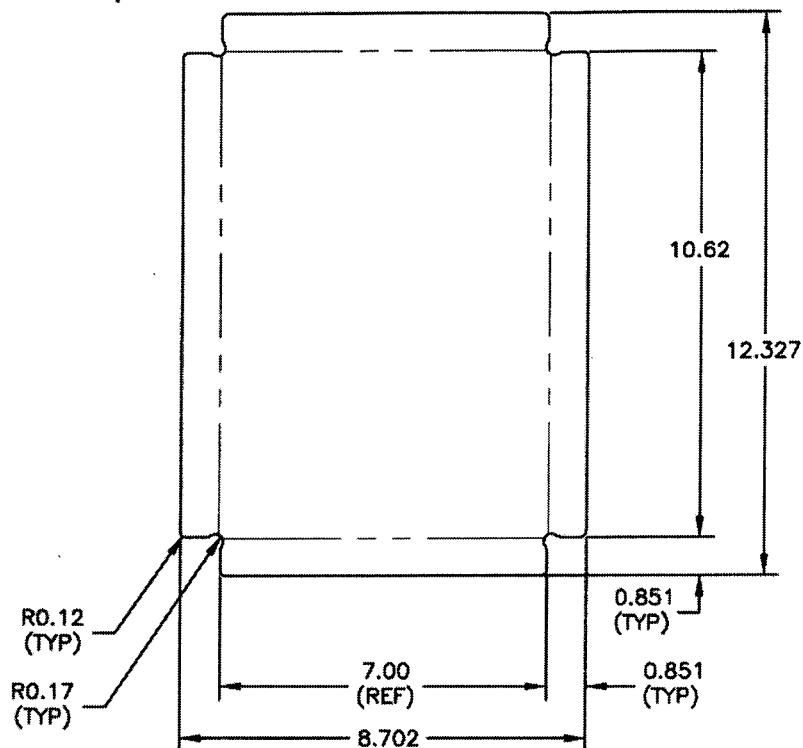
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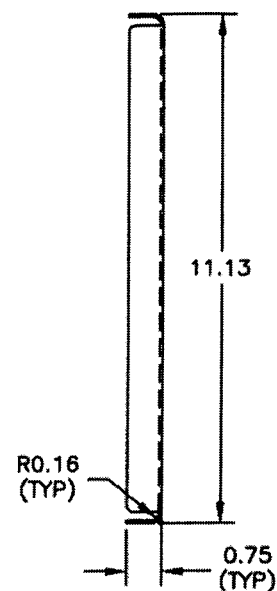


DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3302	REV. B SHEET 3 OF 4
DATE 04.11.08		TITLE DOUBLER	SCALE 1:4

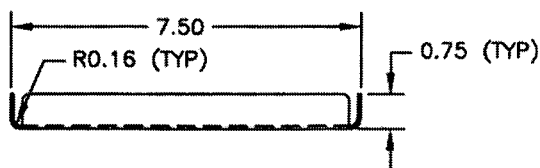
RELEASED
04.11.23



D3302-5 FLAT PATTERN



**D3302-5 DOUBLER
BEND DETAIL**



D3302-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

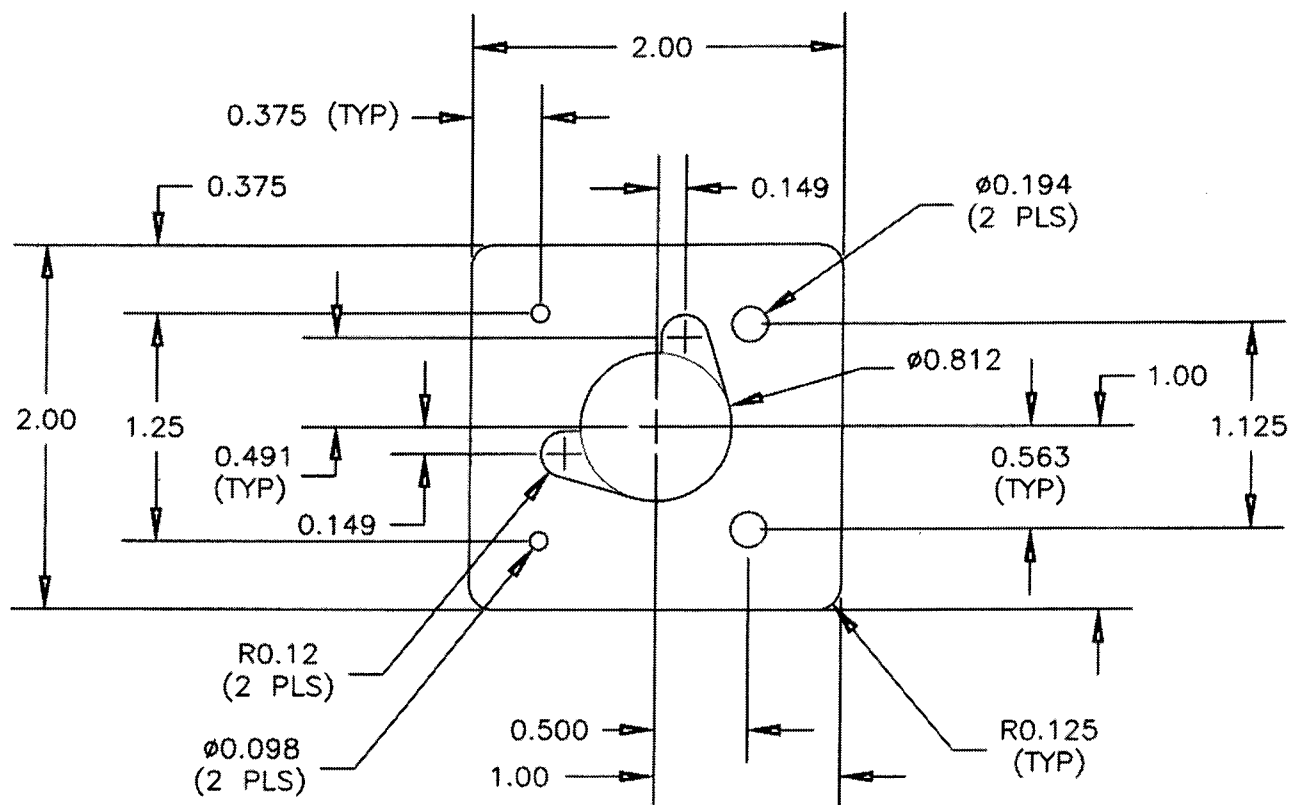
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:1

RELEASED
04.11.23 [Signature]



D3302-7

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6192
Date: 2014-07-10
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24574	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-10
Tracking No.:	

Item No.	Unit	Description	Quantity
646.3711	Chaque	646.3711 clip	40
646.3712	Chaque	646.3712 clip	20
646.3712	Chaque	646.3712 clip	40
646.3713	Chaque	646.3713 gusset	40
646.3714	Chaque	646.3714 gusset	40
646.3717	Chaque	646.3717 doubler	30
646.3719	Chaque	646.3719 doubler	20
646.3719	Chaque	646.3719 doubler	40
d2365	Chaque	d2365 wearplate pin	30
d3283-1	Chaque	d3283-1 doubler	40
d3208-3	Chaque	d3208-3 pedal mount angle	20
d3290-1	Chaque	d3290-1 frame	30
d3302-1	Chaque	d3302-1 doubler	10
d3302-3	Chaque	d3302-3 doubler	10
d3363-1	Chaque	d3363-1 console	16
d4072-3	Chaque	d4072-3 airframe hinge backing plate	40
d4073-3	Chaque	d4073-3 door hinge backing plate	50
d4074-5	Chaque	d4074-5 backing plate	40
d4610-5	Chaque	d4610-5 shim	20

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days